

5/29

DART AEROSPACE LTD	Work Order:	23700
Description: Bracket Assembly	Part Number:	D3121-041
Dwg: D3121 Rev. C2 page 1, 3, 4 D3121-041 replaces Premier P/N B30-23000-33	Qty:	5 Kits
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	CH	05.06.29	5
2	MV	Cut blank: 1.00" x 2.00" x 3.250" Long Bar Material: 17-4 SS per AMS 5604/5643 (M17-4-B1.000x02.000) Batch: <u>M/4773</u> Identify for D3121-11	40	05/08/02	5
3	MV	Machine as per Folio FA331 and Dwg D3121 Identify as D3121-11	EP	05/08/12	5
4	QC2	Inspect parts as they come off the CNC machine	EP	05/08/12	5
5	MV	Deburr. Break all sharp edges 0.005 to 0.015	EP	05/08/12	5
6	MV	Scribe batch number to D3121-11 at the back face.	EP	05/08/12	5
7	QC8	Second check of D3121-11	CH	05/08/31	5
8	GA	Assemble D3121-041 as per Dwg D3121 Pick: Qty Part Number Description Batch 1 D3121-21 Bolt B23914 1 D3121-241 Bearing Assy B21855A	J.L	05.08.13	5
9	QC5	Inspect work to Step 8	ML	05/08/31	5
10	ST	Identify and Stock in Spacedoor cell	CL	05/08/01	5
11	AC	Cost / part: <u>86.21</u>	SK	05.09.02	5
12	DC	Close W/O <u>107.14</u> Inspect Level 21	EP	05/09/02	5

Rev	Date	Change	Revised By	Approved
A	02.05.21	New issue	NG	
B	03.05.02	Reformat	KJ/RF	
C	05.06.09	Hardware revised in Step 8	KJ/JLM	

RELEASED
05/06/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr.	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05/08/12	#3	one part scrap Part came out of Fixture	<i>[Signature]</i>	Scrap/destroy and replace (normal problem with mat.)	EP 05/08/12	<i>[Signature]</i> 05-08-31	<i>[Signature]</i> 05-08-31	<i>[Signature]</i> 05-08-31

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *[Signature]* Date: 05/09/12

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jun 28, 2005
10:11 am

Work Order No : 0023700
Project Name : D3121-041
Project For : WK529
Work Order Type : Main
Main WO Number :
House Part Number : D3121-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 06-28-05
Est Finish Date : 07-21-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DART AEROSPACE LTD		Work Order:	23700
Description: Bracket Assembly		Part Number:	D3121-041
Inspection Dwg: D3121	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.201	± 0.005 ± 0.000	0.203	✓			
0.100	± 0.010	0.099	✓			
0.392	± 0.002 ± 0.000	0.392	✓			
0.75	± 0.030	0.752	✓			
0.375	± 0.010	0.371	✓			
1.96	± 0.030	1.956	✓			
0.300	± 0.010	0.296	✓			
0.573	± 0.010	0.570	✓			
0.345	± 0.010	0.355	✓			
0.300	± 0.010	0.302	✓			
0.080	± 0.010	0.081	✓			
2.56	± 0.030	2.562	✓			
2.14	± 0.030	2.126	✓			
0.130	± 0.010	0.128	✓			
2.57	± 0.030	2.577	✓			
2.85	± 0.030	2.848	✓			
0.400	± 0.010	0.393	✓			
0.381	± 0.010	0.384	✓			
0.201	± 0.010	0.201	✓			
0.580	± 0.010	0.580	✓			
100°	$\pm 1/2^\circ$	100°	✓			
0.032	± 0.010	0.029	✓			

Measured by: CP	Audited by: J.L	Prototype Approval:
Date: 05/08/12	Date: 05.08.31	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/RF	